

NON EUROCOPTER

Work Order ID 63711

November 10, 2010 11:51:58 AM



Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

NON EUROCOPTER

S. 10/16/17

HJ for BG 10-11-16

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R: Aluminum Rod

3-Grind End Plate flush

M108436
M114877

10.11.11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63711

November 10, 2010 11:51:59 AM



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Item ID: D350-591-311

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Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 2E10/11/15

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 LH 1/10/15

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BB 12/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 63711

November 10, 2010 11:52:30 AM

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Item ID: D350-591-311

Accept

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10 Start Qty: 4.00

Required Date: 11/17/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10-11-15

4

0

180

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 1108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10-11-16

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 11/17/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

4 0 BE10/11/10

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Solutio

74
L4

210

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

4/14 BR 10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 63711

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Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 3:30
OVEN TEMPERATURE: 320°
FINISH TIME: 7:00

4 10-11-16

230

Wing Walk as per dwg QSI005 4.4 Batch M115790

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/11/17

4 9

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Cedap/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 63711

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Item ID: D350-591-311

Accept



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Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>72</u>								

10/11/10 5/17

8.00/17

10/11/10 5/17

Rec'd

10/11/10 5/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 63711

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Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/17

MF
10-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

November 10, 2010 11:51:54 AM

Page 1

Work Order ID: 63711

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A[104.03.22]New issue [KJ]/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM[]
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
 by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DS1 9410-011

Manufactured

No

Each

2.0000

4

2x

Step Modification

CHG001

Location

Loc Qty

Loc Code

FG020

2

62191

2

D3067-1

Manufactured

No

110

Each

136.0000

1

4

End Plate

Location

Loc Qty

Loc Code

WA

136

60141

5

62664

131

D3219-1

Manufactured

No

110

Each

61.0000

2

8

Plate

Location

Loc Qty

Loc Code

WA

61

61204

61

D3272-1

Manufactured

No

110

Each

0.0000

1

4

Step

B 63714 10/11/10

10.11.11

10.11.11

10.11.11 363713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

November 10, 2010 11:51:55 AM

Page 2

Work Order ID: 63711

Parent Item: D350-591-311


Parent Item Name: Heli-Access-Step, Long LH


Start Date: 11/10/10

Required Date: 11/17/10


Start Qty: 4.00


Required Qty: 4.00

D3065-041 Manufactured No 180 Each 28.0000 1 4  *11.10.15*


 Step Leg Assembly Hi


Location	Loc Qty	Loc Code
WA	28	
61216	3	
62224	25	

D3066-1 Manufactured No 180 Each 87.0000 2 8  *11.10.15*


 Spacer


Location	Loc Qty	Loc Code
WA	87	
62662	87	

D3067-1 Manufactured No 180 Each 136.0000 1 4  *11.10.15*

 End Plate

Location	Loc Qty	Loc Code
WA	136	
60141	5	
62664	131	

MS20600-AD4W4 Purchased No 180 Each 1,875.000 16 64  *11.10.15*

 Rivets

Location	Loc Qty	Loc Code
ST32i	1875	
113368	38	
114181	11	
114718	2	
115573	147	
115640	677	
116022	1000	

64

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 63711

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

AN3-35A
Bolt

Purchased No

250 Each

106.0000 2 8

Location

Loc Qty

Loc Code

ST353

106

115457

6

115936

100

AN4-13A
Bolt

Purchased No

250 Each

400.0000 8 32

Location

Loc Qty

Loc Code

ST357

400

115936

300

116075

100

AN5-36A
Bolt

Purchased No

250 Each

117.0000 2 8

Location

Loc Qty

Loc Code

ST340

100

115936

100

ST341

17

114292

5

114941

12

AN960JD10

NAS1149D0363J

Purchased No

250 Each

8.0000 4 16

Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 4

Work Order ID: 63711

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No
Washer

250 Each 24.0000 16 64

Location Loc Qty Loc Code

ST300 24
113288 24

AN960JD516 NAS1149D0563J Purchased No
Washer

250 Each 34.0000 4 16

Location Loc Qty Loc Code

ST 34
103694 18
107534 12
109287 4

D2230-3 Manufactured No
Lug

250 Each 30.0000 4 16

Location Loc Qty Loc Code

ST476 30
55452 2
62660 28

D2618 Manufactured No
Bushings

250 Each 103.0000 2 8

Location Loc Qty Loc Code

ST019 101
60772 1
~~62213~~ 100
ST020 2
56892 1
57829 1

MI16025 10/11/10

MI14792 10/11/10

B62927 10/11/10

10/11/10 45

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Page 4

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Page 5

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

D2856-400 *12 @ 720" long* Manufactured No

250 f

142.2500 0.6 2.4



Abraison Strip

Location

Loc Qty

Loc Code

ST403

142.2500421

56626

0.00004211

59920

142.25

250 Each

77.0000 2

D3235-1 Manufactured No



Mounting Lug

Location

Loc Qty

Loc Code

ST471

77

61845

27

62214

50

250 Each

46.0000 1

D3278-041 Manufactured No



Support Assembly

Location

Loc Qty

Loc Code

ST471

46

61212

16

62395

30

250 Each

1,817.000 2

MS21042L3 Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

1817

114784

817

115835

1000

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Page 5

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Parent Item Name: Heli-Access-Step, Long LH



Start Date: 11/10/10

Required Date: 11/17/10

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased No

250

Each

2,668.000

8

32



Nut



12/1/10

Location

Loc Qty

Loc Code

ST300

2668

113422

25

114523

8

115589

1535

115621

1100

32

MS21042L5

Purchased No

250

Each

1,393.000

2

8



Nut



12/1/10

(42)

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1367

115156

167

115594

500

116104

200

116105

500

8

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. E SHEET 1 OF 1
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *th*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

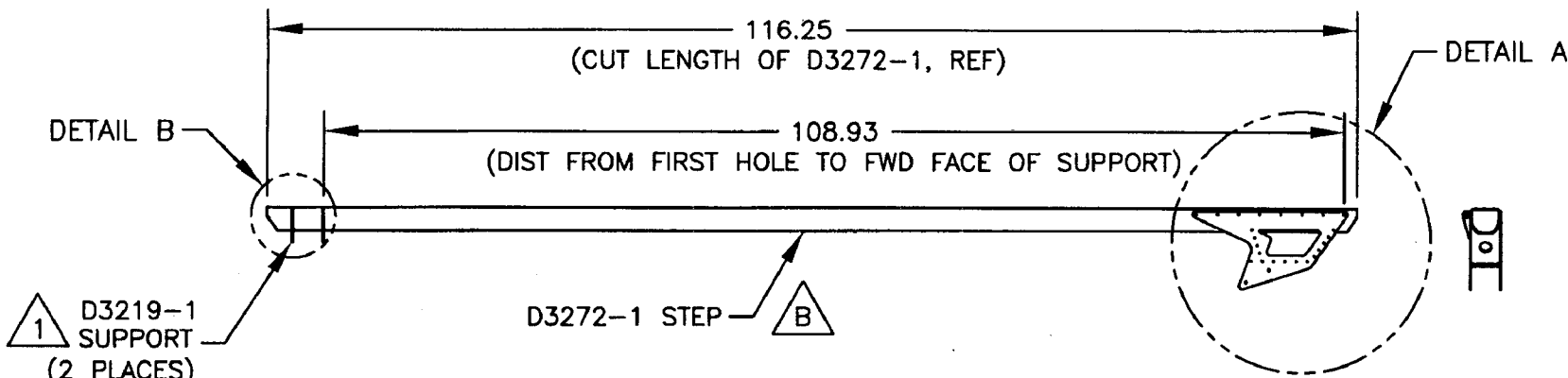
GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

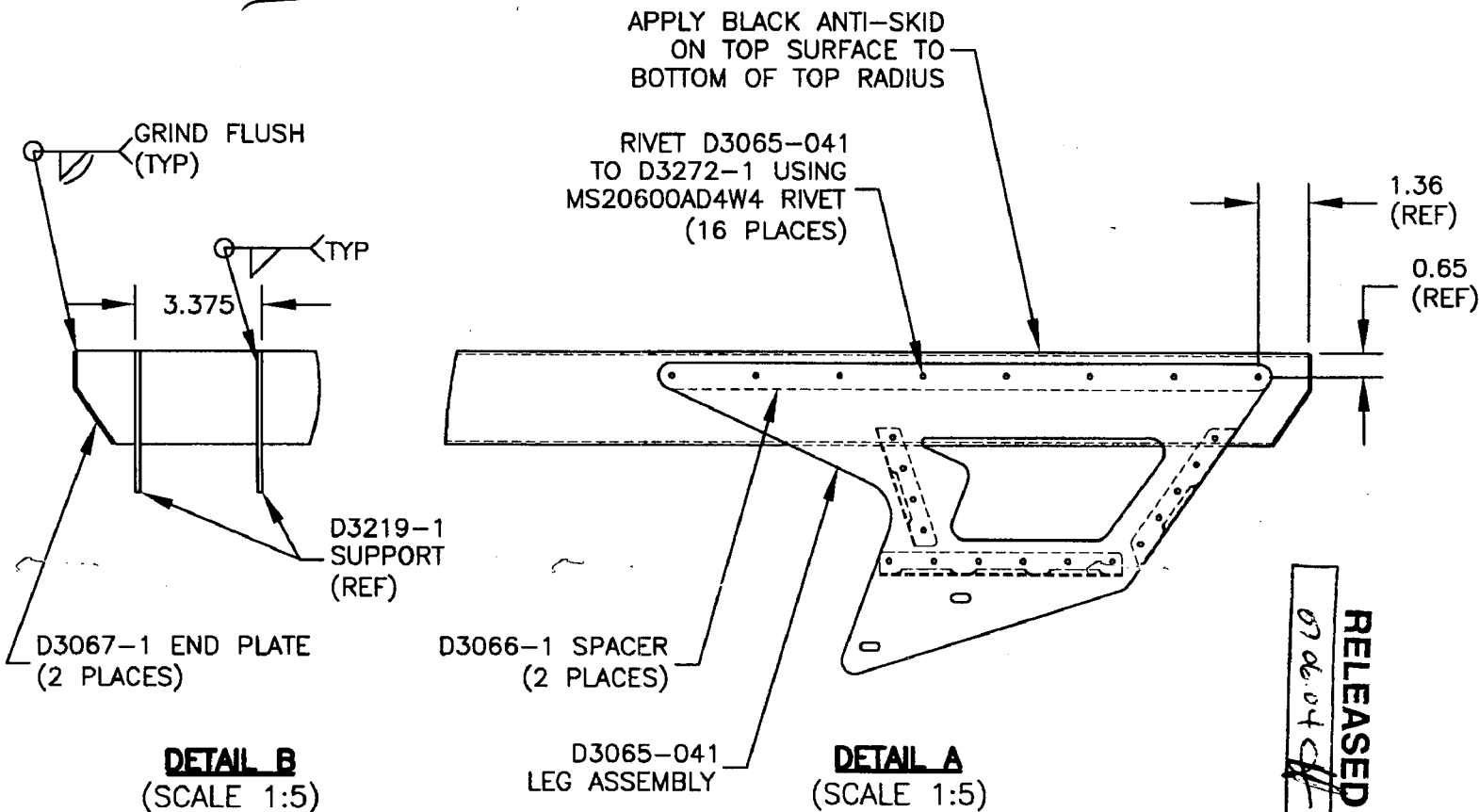
WLB 63711

DART

DESIGN	90	DRAWN BY	RE	DART AEROSPACE LTD	REV. E
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA	
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	DRAWING NO.	D3272
				SHEET 2 OF 2	SCALE



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

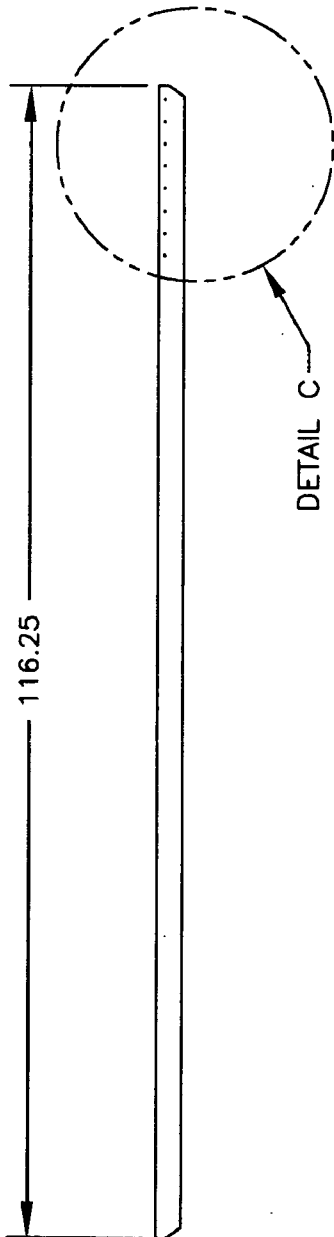


DART

DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

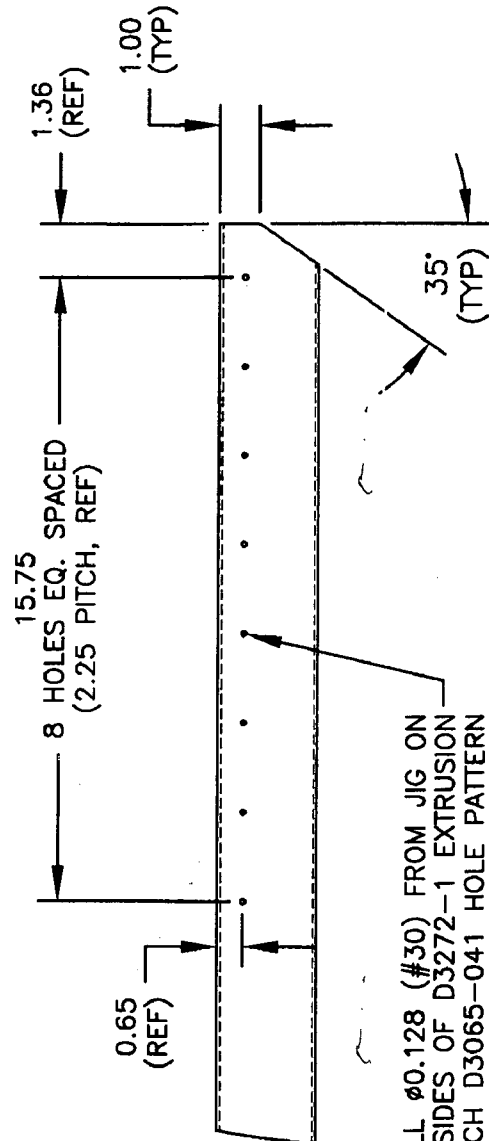
RELEASED

07.06.04 *[Signature]*



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

6374



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.